

Work Order ID 53348

November 2, 2009 10:41:14 AM

Blue



Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

RF

Date:

09/11/02

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2892	Rev A								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS I								
HAAS CNC vertical machine #1	Memo Machine as per Folio FA082 Tumble & Deburr	0.00							
				<i>mwf</i> <i>09/11/04</i>		<i>12</i>	<i>0</i>		
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
				<i>mwf</i> <i>09/11/04</i>		<i>12</i>	<i>0</i>		
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							
				<i>DT</i> <i>09/11/05</i>		<i>12</i>			

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Page 2

Item ID: D2892-1

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Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo Prime B110199 Spray Paintat Delfleet Blue B113171 Clear Delfleet B113088	0.00 0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>15 (12)</u>
135 QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>RT</u>	<u>09</u>	<u>11-16</u>	
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>8-1605</u> <u>Paint</u> Memo	0.00 0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>16 (12)</u>

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Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/16

MF
09-11-16

Picklist Print

November 2, 2009 10:41:18 AM

Page 1

Work Order ID: 53348



Parent Item: D2892-1RevA



Parent Item Name: Support

Start Date: 02/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK077RevA		Manufactured	No			110	Each	17.0000	6.0000			



D2892-1 TURNING DETAIL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

17

42245

4

43386

6

43869

7

mmk
09/11/03

6

DART AEROSPACE LTD		Work Order:	5334/8
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.130	.130	.131	.130	.130
AB	0.290	0.310		.308	.306	.306	.300	.305
AC	0.040	0.060		.050	.047	.050	.050	.047
AD	0.115	0.135		.126	.126	.125	.125	.124
AE	0.240	0.260		.251	.251	.252	.249	.250
AF	0.188	0.193		.190	.191	.190	.170	.190
AG	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AH	1.126	1.146	✓ 1.144	1.144	1.144	1.143	1.144	1.143
AI	0.454	0.474		.454	.454	.463	.462	.460
AJ	0.240	0.260		R.250	R.250	R.250	R.250	R.25
AK	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AL	0.257	0.262		.259	.259	.258	.258	.253
AM	1.663	1.683		1.664	1.665	1.667	1.675	1.677
AN	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AO	0.022	0.042		R.032	R.032	R.032	R.032	R.032
AP	2.779	2.789		2.783	2.783	2.785	2.785	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	mmw	Date:	09/11/03
Audited by:	STP	Date:	09/11/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 53348
Description: 2.500 Support		Part Number: 2892-1
Inspection Dwg: 02892 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance		6	7	8	9	10
	Min	Max					
AA	.115	.135	.130	.131	.132	.132	.131
AB	.290	.310	.304	.306	.310	.310	.310
AC	.040	.060	.047	.054	.055	.050	.050
AD	.115	.135	.125	.125	.124	.124	.125
AE	.240	.260	.250	.250	.247	.247	.250
AF	.188	.193	.190	.190	.190	.190	.190
AG	.240	.260	R.250	R.250	R.250	R.250	R.250
AH	1.126	1.146	1.138	1.144	1.144	1.142	1.145
AI	.454	.474	.467	.461	.462	.461	.461
AJ	.240	.260	R.250	R.250	R.250	R.250	R.250
AK	.053	.073	R.063	R.063	R.063	R.063	R.063
AL	.257	.262	.259	.258	.258	.258	.258
AM	1.663	1.683	1.678	1.678	1.678	1.673	1.677
AN	.053	.073	R.063	R.063	R.063	R.063	R.063
AO	.032	.042	R.032	R.032	R.032	R.032	R.032
AP	2.779	2.789	2.784	2.783	2.783	2.783	2.783

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 09/11/04	Date: 09/11/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 53348
Description: Ø 2.500 Support	Part Number: 2892-1
Inspection Dwg: D2892 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

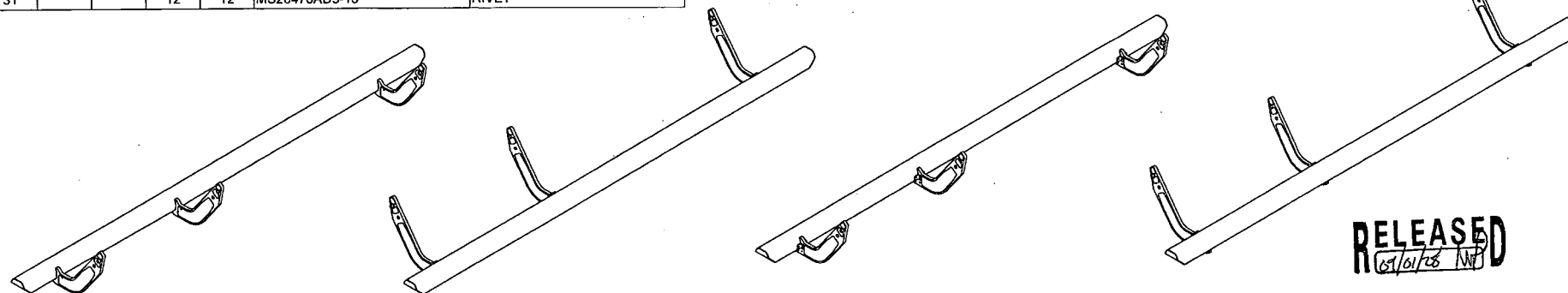
Drawing Dimension	Tolerance		11	12		Method of Inspection	Comments
	Min	Max					
AA	.115	.135	.131	.130			
AB	.290	.310	.310	.310			
AC	.040	.060	.052	.053			
AD	.115	.135	.125	.124			
AE	.240	.260	.247	.247			
AF	.188	.193	.190	.190			
AG	.240	.260	R.250	R.250			
AH	1.126	1.146	1.139	1.138			
AI	.454	.474	.463	.463			
AJ	.240	.260	R.250	R.250			
AK	.053	.073	R.063	R.063			
AL	.257	.262	.258	.258			
AM	1.663	1.683	1.672	1.673			
AN	.053	.073	R.063	.063			
AO	.032	.042	R.032	R.032			
AP	2.779	2.789	2.783	2.783			

Measured by: mtf	Audited by: DJP	Prototype Approval: N/A
Date: 09/11/04	Date: 09/11/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM No.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2812-041	STEP WELDMENT
2		X			D2812-042	STEP WELDMENT
3			X		D2812-043	STEP ASSEMBLY
4				X	D2812-044	STEP ASSEMBLY
11	1	1	1	1	D2812-1	STEP
15	1				D2795-1	ARM
16		1			D2795-2	ARM
17			1		D2795-3	ARM
18				1	D2795-4	ARM
19	2				D2795-041	ARM ASSEMBLY
20		2			D2795-042	ARM ASSEMBLY
21			2		D2795-043	ARM ASSEMBLY
22				2	D2795-044	ARM ASSEMBLY
19	2	2	2	2	D2875	END PLATE
20			6	6	D3730-1	ANGLE
21			6	6	D3741-1	ANGLE
30			24	24	CR3213-5-4	RIVET
31			12	12	MS20470AD5-16	RIVET

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NO. 53348
BP09-11-2



D2812-041 STEP WELDMENT

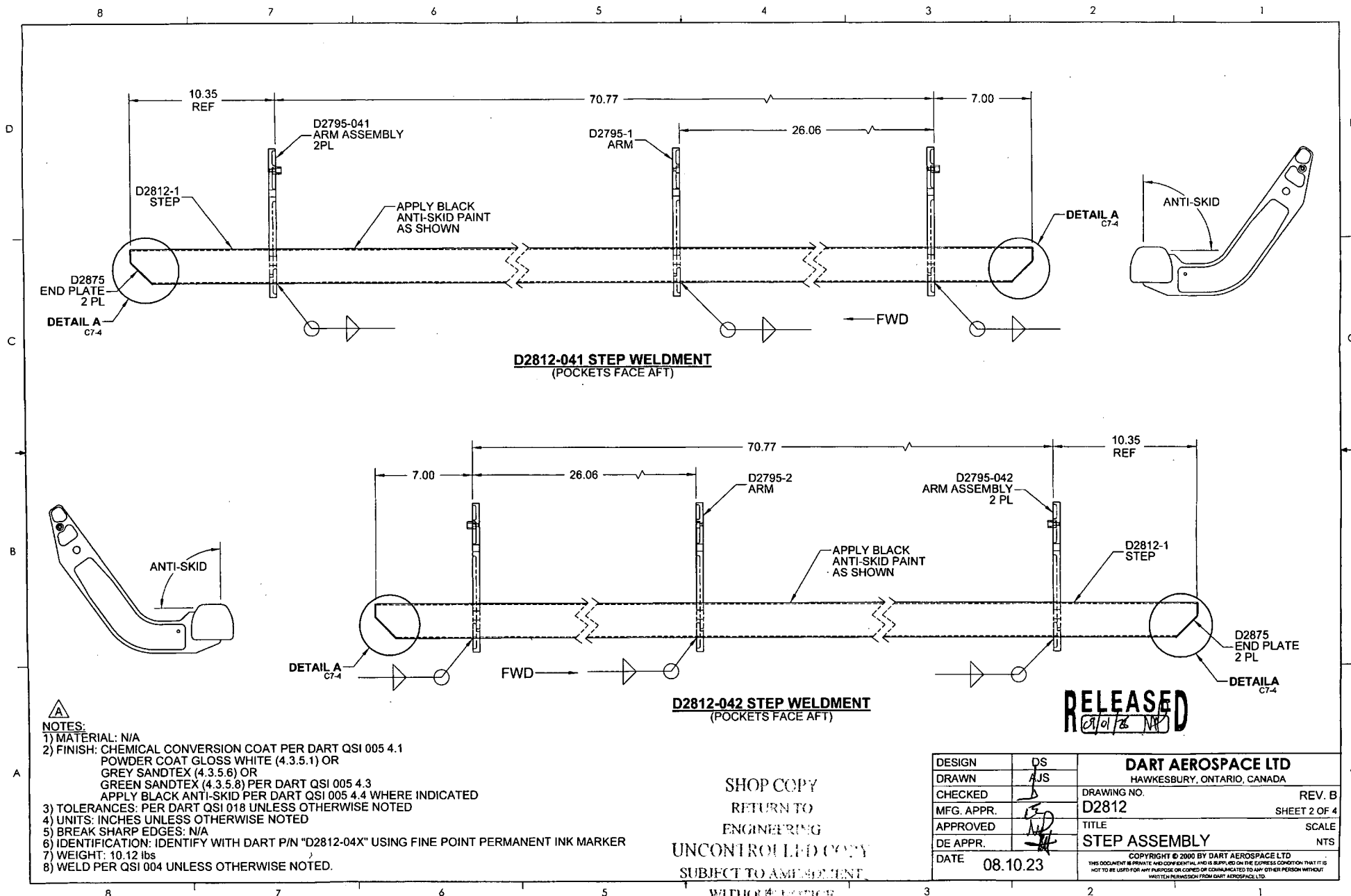
D2812-042 STEP WELDMENT

D2812-043 STEP ASSEMBLY

D2812-044 STEP ASSEMBLY

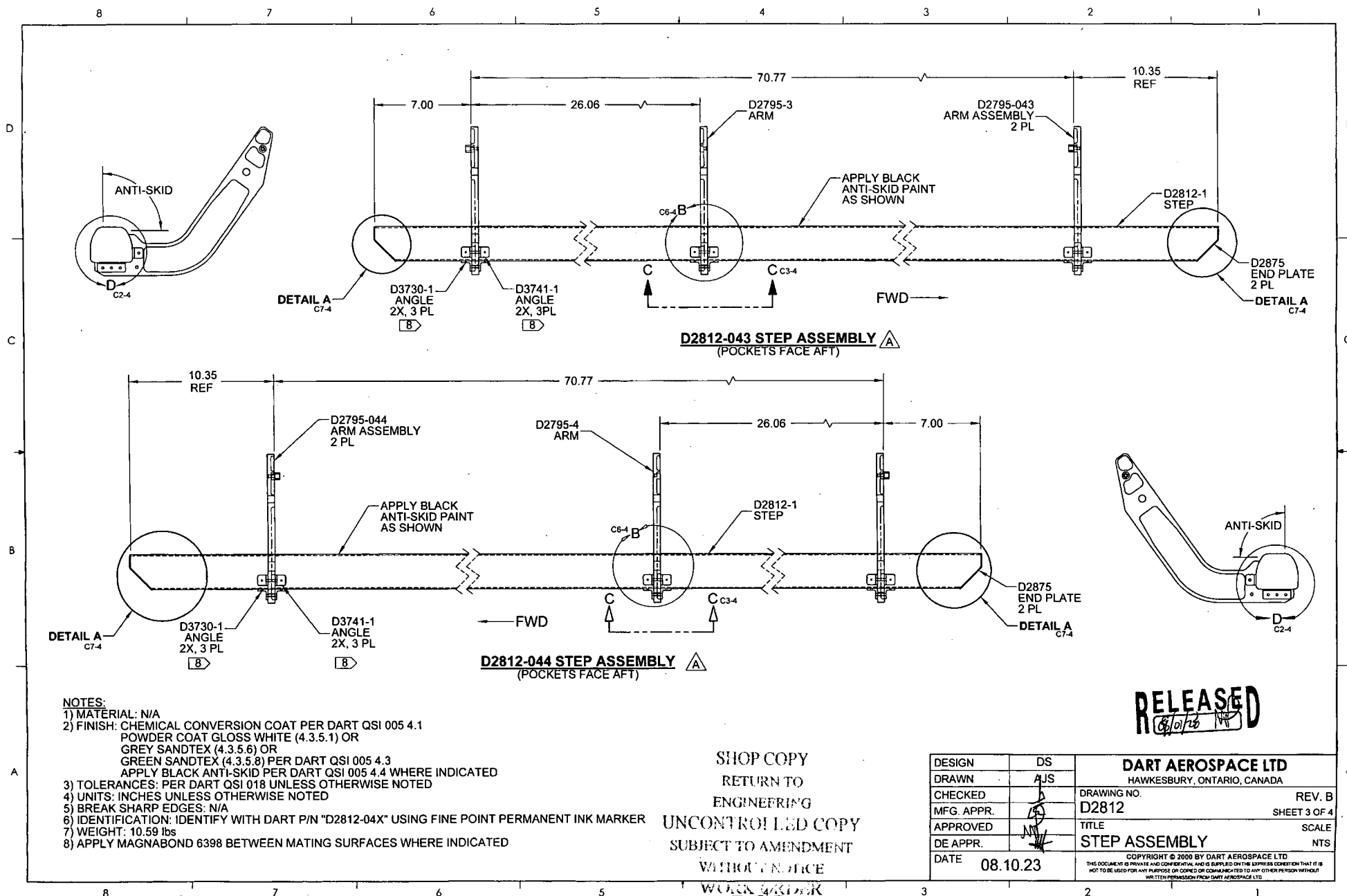
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6/1/03 NP

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS -041 & -042 UNCHANGED. ADDED -043 & -044 TO ELIMINATE NEED FOR WELDING.		AJS	08.10.23
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO. D2812	REV. B	
MFG. APPR.		SHEET 1 OF 4		
APPROVED		TITLE	SCALE	
DE APPR.		STEP ASSEMBLY	NTS	
DATE	08.10.23	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



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NO. 53347



8

7

6

5

4

3

2

1

D

C

B

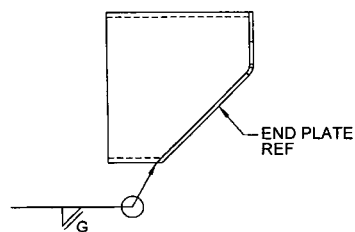
A

D

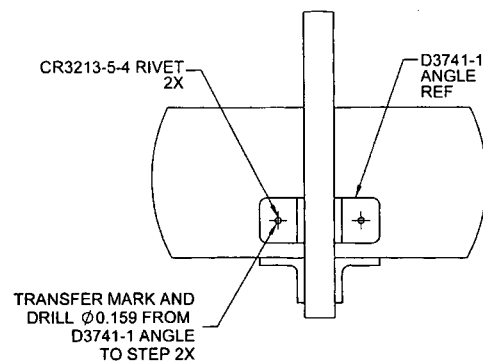
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B

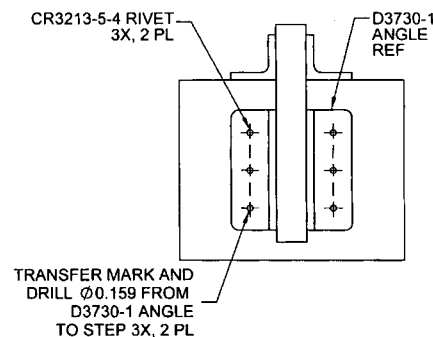
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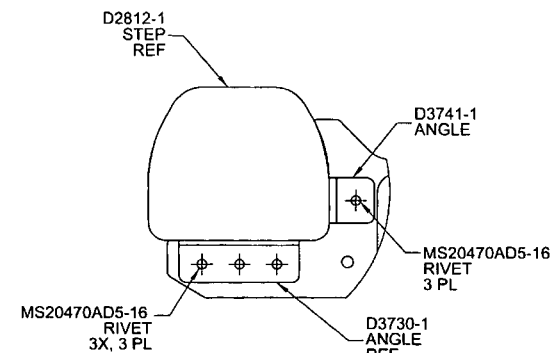
DETAIL A
SCALE 3X
C8-2 C7-3
D2-2 C1-3
A7-2 B8-3
A1-2 B2-3



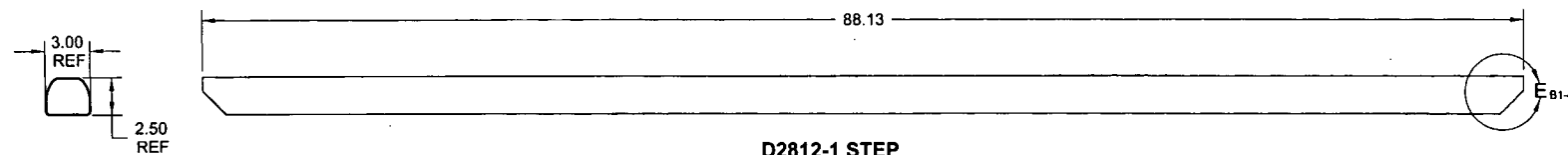
DETAIL B
SCALE 3X
D5-3 B5-3
3 PL



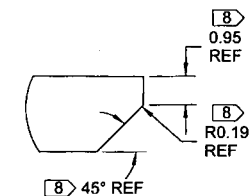
DETAIL C
SCALE 3X
C4-3 B4-3
3 PL



DETAIL D
SCALE 3X
C8-3 B1-3



D2812-1 STEP







DETAIL E
SCALE 2X
B2-4
2 PL

D2812-1 NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.46 lbs
- 8) SHAPE TO FIT D2875 END PLATE

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NO. 53348

RELEASED
2/1/8 MP

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2812	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	NTS
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